

Reprint

ORD 11475



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1270 Aberdeen St
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Canada

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D206-642-151
Job Sheet 171320

**Part No:** D206-642-151**Job Qty:** 1 ea**Part Name:** Replacement Skidtube, Low Gear with Run-on Landing Fits LH or RH**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 1/31/18**Job Tracking No:****Due Date:** 2/12/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:**

Note: DWG D3804 REV A(DEO), IIN-D206-642 REV Q SHEETS 13,26 IPP REV:A 10.12.08 PER IIN REV.N DD
VERF:EC IPP REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP Rev:C 12.11.22 now swage per ecn12-679
DD verf:JLM IPP Rev:D 14.04.24 ECN14-520 DD verf:JLM IPP Rev:E 16.04.04 as per CHG004(ecn16-553)
DD verf:JLM

Ship Via:**Bill of Materials**

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Container No: S134578**Part:** D206-642-151**Job No:** 171320**Serial No/Batch:** S134578**Revision:****Inspector:****Exp Date:****Instructions:** TC STC SH98-4 Issue 2, FAA STC SA00475SE 15/10/28, EASA STC

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
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Other/Details: _____ _____ _____																																			

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/9/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		2/9/18	0.00	1.82	Skidtubes-2		
120	QC	1 pcs		2/9/18	0.00	0.00	QC6		
130	QC	1 pcs		2/9/18	0.00	0.00	QC9		
140	HandFinish	1 pcs		2/9/18	0.00	0.33	HandFinish1		
150	QC	1 pcs		2/9/18	0.00	0.00	QC7-1		
160	Skidtubes	1 pcs		2/10/18	0.00	2.00	Skidtubes-2		
180	Skidtubes	1 pcs		2/10/18	0.00	1.82	Skidtubes-2		
190	QC	1 pcs		2/10/18	0.00	0.00	QC5		
200	Skidtubes	1 pcs		2/10/18	0.00	2.84	Skidtubes-2		
215	QC	1 pcs		2/10/18	0.00	0.00	QC9		
220	QC	1 pcs		2/10/18	0.00	0.00	QC10		
230	QC	1 pcs		2/10/18	0.00	0.00	QC5		
240	HandFinish	1 pcs		2/10/18	0.00	0.78	HandFinish2		
250	Powdercoat	1 pcs		2/10/18	0.00	0.25	Powdercoat1		
260	QC	1 pcs		2/10/18	0.00	0.00	QC3		
270	HandFinish	1 pcs		2/10/18	0.00	0.60	HandFinish4		
280	HandFinish	1 pcs		2/12/18	0.00	0.60	HandFinish3		
290	QC	1 pcs		2/12/18	0.00	0.00	QC3		
300	QC	1 pcs		2/12/18	0.00	0.00	QC5		
305	DC	1 pcs		2/12/18	0.00	0.00	DC		
310	Packaging	1 pcs		2/12/18	0.00	0.00	Packaging3-1		
320	QC21-FG	1 Ea		2/12/18	0.00	0.00	QC21		

Part Op 110 - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

160 - 1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B(without cutting fluid) 3-Deburr and blow out all chips from inside the tube 180 - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

250 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ 270 - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

305 - Photocopy bluefile & type labels per PPP D206-642-151 CHG004

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

M138997 START: 1:30 TEMP: 300° FINISH: 2:00

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 Ea (1 ea)	90-Start up Operation	5108902
D2647	Cap	1 Ea (1 ea)	90-Start up Operation	5038805
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	180-Skidtubes	FM137622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	180-Skidtubes	FM137886-1
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes	5045670 X 11
D2654-1	Web	1 Ea (1 ea)	180-Skidtubes	5060133
D3286-1	Doubler	2 Ea (2 ea)	180-Skidtubes	5049486
D2649	Cross Bolt Spacer	1 Ea (1 ea)	200-Skidtubes	5050570
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes	191160
D4720-1	Spacer	18 Ea (18 ea)	200-Skidtubes	5030687
D2651-1	Plug	6 Ea (6 ea)	270-HandFinish	5044163
D2651-3	O-Ring	6 Ea (6 ea)	270-HandFinish	5027457
D2680-041	Nut Plate	1 pcs (1 ea)	270-HandFinish	158429
AN3-37A	Bolt	7 Ea (7 ea)	280-HandFinish	5130486
D2646	Aft Cap	1 Ea (1 ea)	280-HandFinish	51163254-10
D3805-041	Run-on Landing Wearplate Fwd	1 Ea (1 ea)	280-HandFinish	5143383
D3805-045	Run-on Landing Wearplate Aft	1 Ea (1 ea)	280-HandFinish	5143359
D3873-1	Bushing	14 Ea (14 ea)	280-HandFinish	5137817
MS21042L3	Nut	7 Ea (7 ea)	280-HandFinish	5094542
MS27039-1-08	Screw	2 Ea (2 ea)	280-HandFinish	5043214
MS27039-4-06	Screw	1 Ea (1 ea)	280-HandFinish	FM1137951-1
NAS1149D0332J	Washer	2 Ea (2 ea)	280-HandFinish	5100407
NAS1149D0363J	Washer	7 Ea (7 ea)	280-HandFinish	5123438
NAS1149D0463J	Washer	1 Ea (1 ea)	280-HandFinish	5135801

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	10	0
	D2647	1	22	0
180-Skidtubes	CCR264SS3-3	2	306	0
	CR3212-4-03	2	182	0
	CR3212-4-04	52	623	0
	D2654-1	1	10	0
	D3286-1	2	36	0
200-Skidtubes	D2649	1	104	0
	D3286-3	2	10	0
	D4720-1	18	121	0
270-HandFinish	D2651-1	6	232	0
	D2651-3	6	609	0
	D2680-041	1	37	0
280-HandFinish	AN3-37A	7	76	0
	D2646	1	50	0
	D3805-041	1	0	0
	D3805-045	1	1	0
	D3873-1	14	68	0
	MS21042L3	7	3,378	0
	MS27039-1-08	2	672	0
	MS27039-4-06	1	31	0
	NAS1149D0332J	2	1,786	0
	NAS1149D0363J	7	1,914	0
	NAS1149D0463J	1	4,221	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042) ☐
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Description Work Order Deviation	Disposition	Completed By _____
		Lead hand / Supervisor _____
		QC / QA Coordinator _____

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
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